

Work Order ID 67511

Saturday, March 26, 2011 9:01:02 AM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 3/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *MX*Date: *11-03-27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3913

A

D4042

A

100



Large Fab

Weld per dwg A/R S.S. rod Batch: *1114649* 0.00
Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3913 using DT9610A
inspect before welding mesh
2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

11.03.31 (1x)

110



QC

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

Quality Control

11.03.31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Sub 83/31

(20)

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

1 BL 11-3-31

Hand Finishing

W/O:		WORK ORDER CHANGES						
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Page 3

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Accept



Setup Start



Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop



Start Date: 3/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat									
Powder Coating	<p>Memo</p> <p>1- Plug holes and mask only interior of hinge (3) prior to powder coat</p> <p><i>M115951</i></p> <p>1ST COAT:</p> <p>START TIME: <i>2:50</i></p> <p>OVEN TEMPERATURE: <i>400°</i></p> <p>FINISH TIME: <i>3:20</i></p> <p>***** 2nd coat if necessary*****</p> <p>2ND COAT:</p> <p>START TIME: _____</p> <p>OVEN TEMPERATURE: _____</p> <p>FINISH TIME: _____</p>	0.00							
140 	QC3- Inspect Part Finish	0.00							
QC									
Quality Control	<p>Memo</p>	0.00							

1 BL 11-3-31

1 6 11/10/31 51

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Page 4

Item ID: D3913-041

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Start Date: 3/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



HandFinish

Assemble as per dwg

0.00

Memo

0.00

Hand Finishing

Pick Kit

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location GA

0.00

Memo

0.00

67510

W/O:		WORK ORDER CHANGES						
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/4

MF
11-04-01

W/O:		WORK ORDER CHANGES						
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Picklist Print

Saturday, March 26, 2011 9:00:58 AM

Page 1

Work Order ID: 67511

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/28/2011

Required Date: 4/7/2011


Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-10A  Bolt		Purchased	No			150	Each	43.0000	6	6			
---	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--


Location	Loc Qty	Loc Code
ST351	43	
116075	2	
116400	41	

AN960JD8  Washer	NAS1149DN832J	Purchased	No			150	Each	10.0000	2	2			
--	---------------	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST347	10	
105059	10	

✓ D2581  Mounting Bracket		Manufactured	No			100	Each	38.0000	2	2			
---	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA005	38	
66500	14	
66806	24	

D2931  Bumper		Manufactured	No			150	Each	702.0000	2	2			
---	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST504	702	
46064	702	

W/O:		WORK ORDER CHANGES						
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Picklist Print

Saturday, March 26, 2011 9:00:59 AM

Page 2

Work Order ID: 67511

Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00



✓ D3913-1 Manufactured No 100 Each 3.0000 1 1

 Rib  B65853x 11-03-28

Location Loc Qty Loc Code
 WA006 3
 66629 3



✓ D3913-15 Manufactured No 100 Each 3.0000 1 1

 Wide Handle Plate  11-03-28

Location Loc Qty Loc Code
 WA005 3
 66695 3

✓ D3913-3 Manufactured No 100 Each 2.0000 1 1

 Rib  11-03-28

Location Loc Qty Loc Code
 WA006 2
 65314 1
 65852 1

✓ D3913-7 Manufactured No 100 Each 8.0000 2 2

 Rib  11-03-28

Location Loc Qty Loc Code
 WA006 8
 65278 2
 66435 6

Saturday, March 26, 2011 9:00:59 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Saturday, March 26, 2011 9:00:59 AM

Page 3

Work Order ID: 67511

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-9 Manufactured No 100 Each 5.0000 1 1
Hinge Rib
11.03.28

✓ D3916-041 Manufactured No 100 Each 3.0000 2
Rib Assembly
11.03.28

✓ D3916-5 Manufactured No 100 Each 4.0000 3
Light Rib
11.03.28

✓ D4016-1 Manufactured No 100 Each 16.0000 3
Hinge Half, Base
11.03.28

Location Loc Qty Loc Code

WA006 5
66630 2
67126 3

Location Loc Qty Loc Code

WA 3
65921 3

Location Loc Qty Loc Code

WA006 4
57023 1
66436 3

Location Loc Qty Loc Code

WA005 16
66418 16

Saturday, March 26, 2011 9:00:59 AM

Shop Packet Print

Page 3

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Saturday, March 26, 2011 9:00:59 AM

Page 4

Work Order ID: 67511

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4017-7

Manufactured No

100

Each

6.0000

1

1



Rib



11.03.28

Location

Loc Qty

Loc Code

WA005

6

58929

2

66546

1

66885

3

(1x)

✓ D4017-9

Manufactured No

100

Each

6.0000

2

2



Rib



11.03.28

Location

Loc Qty

Loc Code

WA006

6

66886

6

(2x)

✓ D4020-11

Manufactured No

100

Each

8.0000

2

2



End Mesh, Basket



11.03.30

Location

Loc Qty

Loc Code

WA

8

59413

1

61306

1

67094

6

(2x)

Saturday, March 26, 2011 9:00:59 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Saturday, March 26, 2011 9:00:59 AM

Page 5

Work Order ID: 67511

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4021-1 Manufactured No 100 Each 17.0000
Handle Plate



3 3
11.03.28

Location	Loc Qty	Loc Code
ST109	5	
57086	5	
WA005	12	
56044	3	
65848	1	
66697	8	

D4021-5 Manufactured No 150 Each 15.0000
Blanking Plate



2 2
11.04.01

Location	Loc Qty	Loc Code
ST110	3	
64243	2	
65675	1	
WA005	12	
67008	12	

✓ D4034-041 Manufactured No 100 Each 4.0000
Aft Upper Rib Assembly



1 1
11.03.28

Location	Loc Qty	Loc Code
WA006	4	
66536	1	
66884	3	

1x

Saturday, March 26, 2011 9:00:59 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES						
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Saturday, March 26, 2011 9:00:59 AM

Page 6

Work Order ID: 67511

Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350



Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4034-043 Manufactured No 100 Each 3.0000 1 1

 Fwd Upper Rib Assembly
 11.03.28



✓ M304EX0.75-16F Purchased No 100 sf 470.0000 33 33

 Expanded Metal Flat SS
 11.03.30

Location Loc Qty Loc Code

WA006 3
 66883 3
 470.0000 33



Location Loc Qty Loc Code

WA 470.000043
 114809 0.000043
 115012 150
 117197 320

MS20600-AD4W3 Purchased No 150 Each 1,173.000 2 2

 Cherry Rivets
 11.04.01

Location Loc Qty Loc Code

ST321 517
 111636 517
 WA018 656
 107939 656

MS21042L3 Purchased No 150 Each 2,187.000 6 6

 Nut
 11.04.01

Location Loc Qty Loc Code

ST300 2187
 116391 587
 116540 800
 116549 800

Saturday, March 26, 2011 9:01:00 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES						
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Saturday, March 26, 2011 9:01:00 AM

Page 7

Work Order ID: 67511



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 3/28/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

64.0000

12

12



SB 11/04/01

WASHER

Location

Loc Qty

Loc Code

ST275

64

18057

64

12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

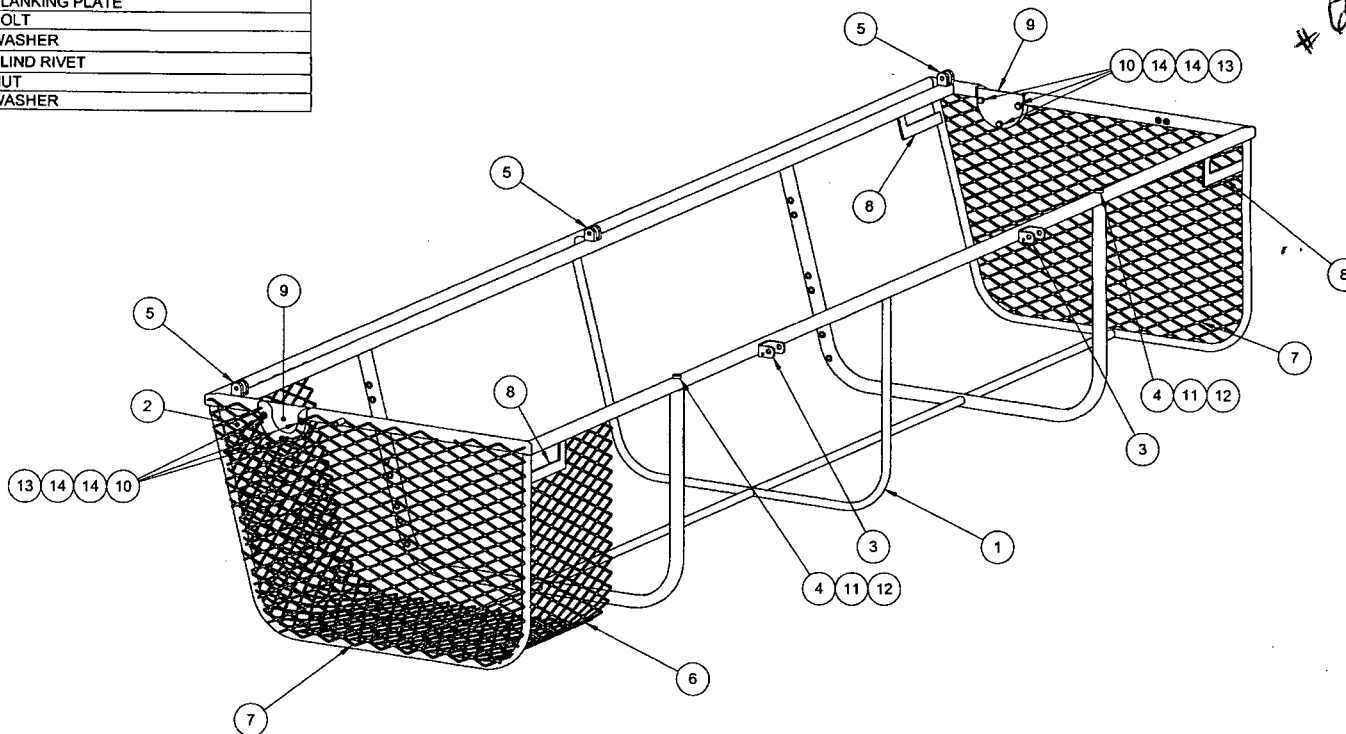
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JWP

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3913 TITLE LONG BASKET BASE ASSY (350) NTS SCALE SHEET 1 OF 6 REV. A COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

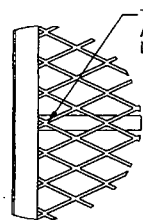
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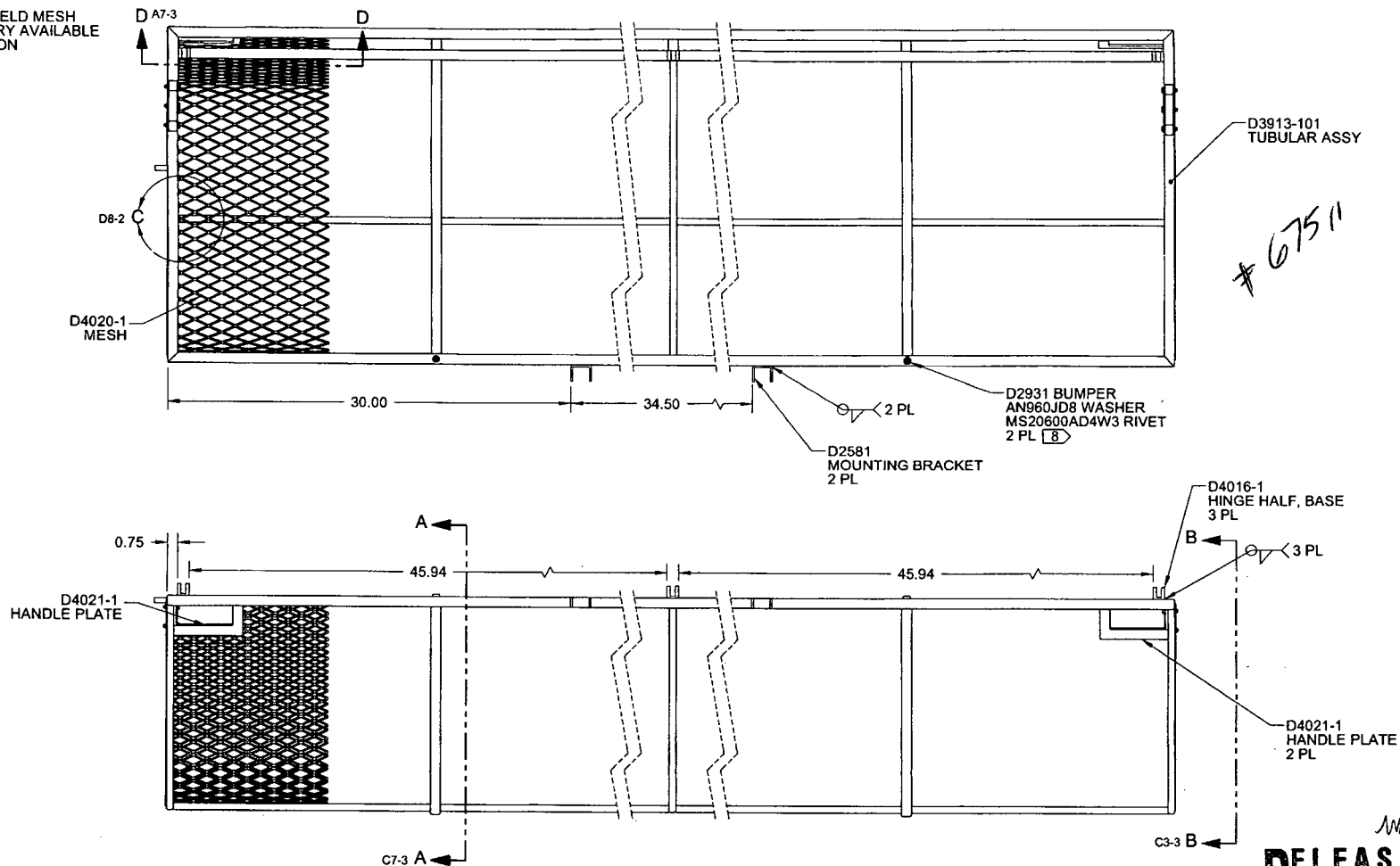
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NOTE: Date & initial all entries



DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-02-27

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

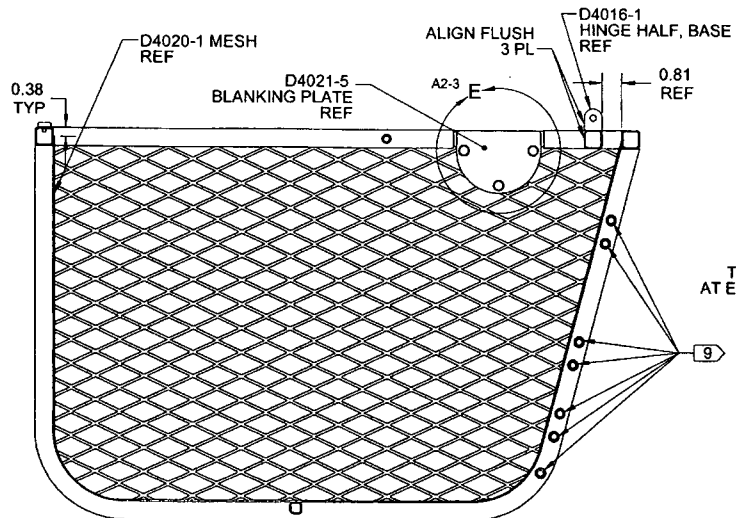
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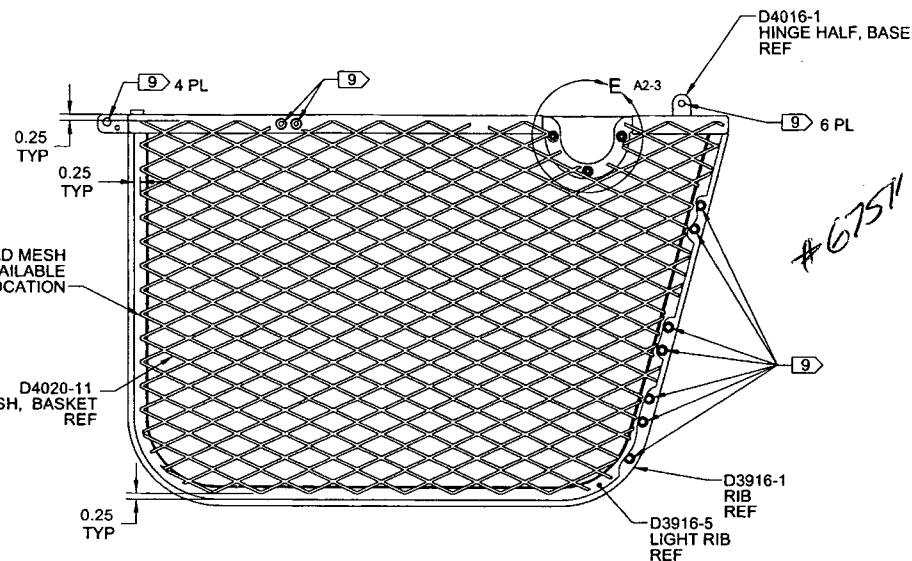
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

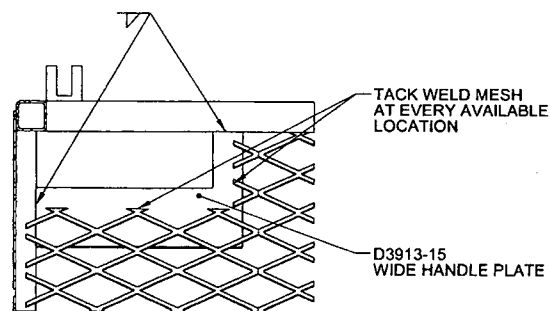
NOTE: Date & initial all entries



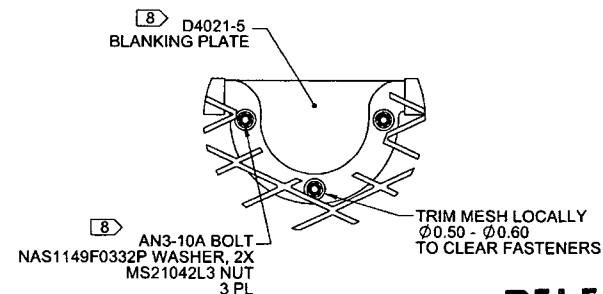
SECTION A-A A5-2







VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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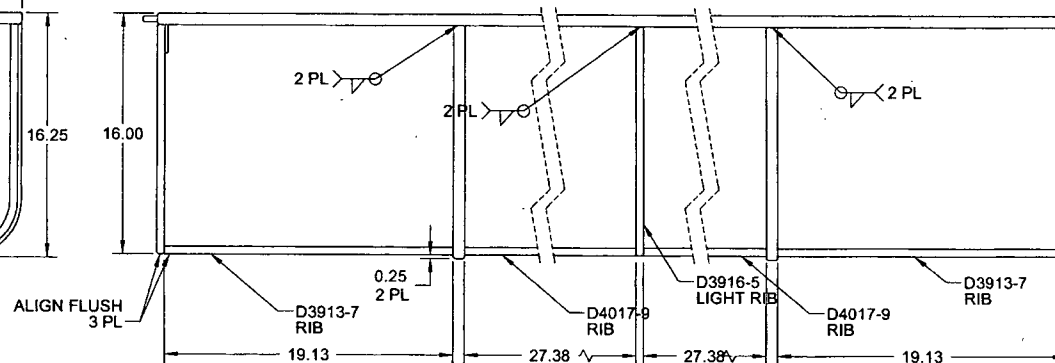
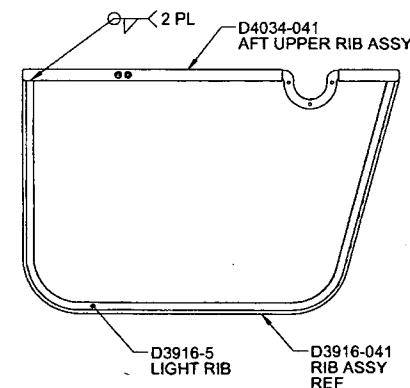
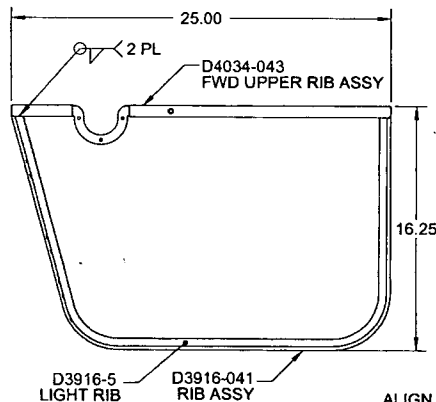
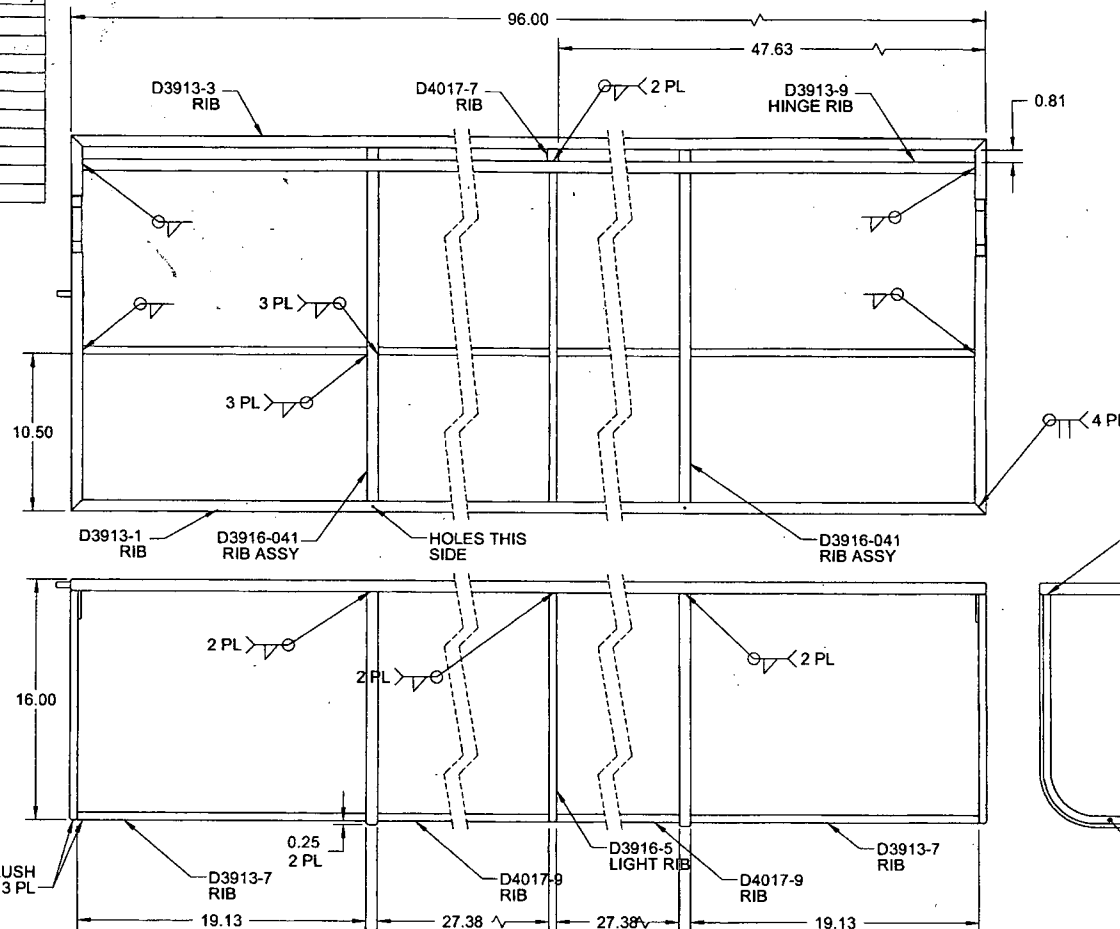
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 22.53 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
 - 9) WELD PER DART QSI 004

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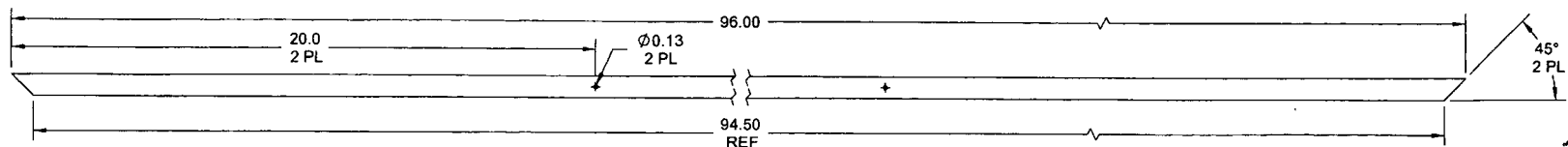
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

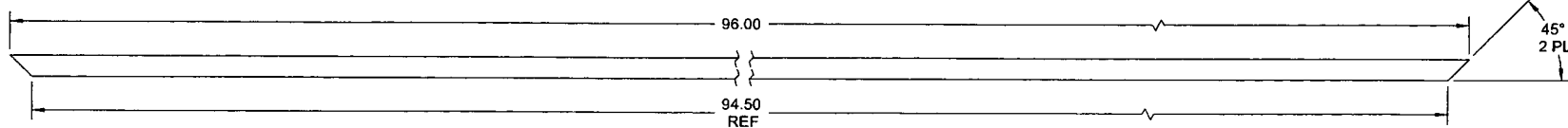
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

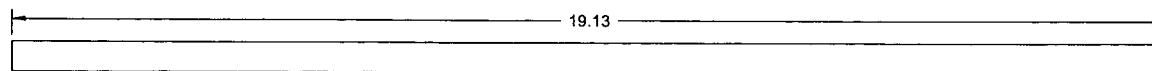
NOTE: Date & initial all entries



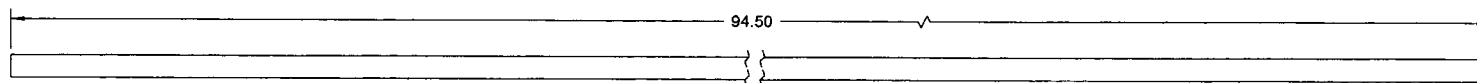
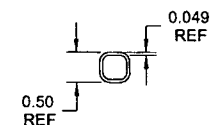
D3913-1 RIB



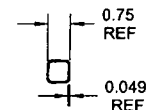
D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB



NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

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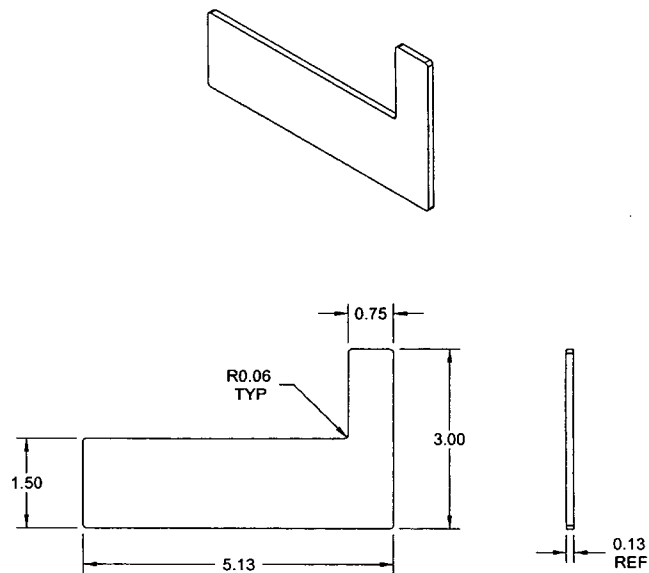
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries